

C1
amended
housing including a threaded hole extending through a bush made directly through a wall of said pipe element,

wherein said bush has an interior portion and an exterior portion, said interior portion extending further within an interior of said pipe element than said exterior portion extends beyond an exterior of said pipe element.

Sub D27
13. (Once Amended) A process for making an exhaust device for an internal combustion engine, said process comprising the steps of:

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forming an integral housing in a pipe element adapted to carry a flow of exhaust gases from the engine, the housing being formed from a flow-drilling operation comprising drilling through a wall of the pipe element with a tool at a speed and a penetration force adapted to cause melting and upsetting of a material of the wall around the tool in proportion to an advance of this tool until a bush of required height and diameter is obtained, wherein the bush has an interior portion and an exterior portion, the interior portion extending further within an interior of the pipe element than the exterior portion extends beyond an exterior of the pipe element;

tapping a hole through the bush to form internal threads in the hole; and

mounting within the housing a measuring transducer configured to analyze a flow of exhaust gases from the engine.

Please add the following new claims:

--18. (New) The process according to Claim 13, wherein the speed of the tool is greater than 500 rpms.

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19. (New) The process according to Claim 18, wherein the speed of the tool is between 3000 rpms and 5000 rpms.--